



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2745**Job Sheet 207470****Part No:** D2745**Job Qty:** 50 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/26/20**Job Tracking No:****Due Date:** 3/20/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV B IPP C 02.03.07 Update to turn in house NG IPP Rev:D 07-10-23 Removed tumbling JLM Verified By:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
100	Hardinge - 1	50 pcs	3/20/20	3/20/20	0.01	2.00	Hardinge - 1		66	20/03/12
120	QC 8	50 pcs	3/20/20	3/20/20	0.00	0.00	QC 8 - 12		9-89	
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			20-03-12
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
							QC 8 - 57			
							QC 8 - 76			
							QC 8 - 61			
130	Packaging 3-1 - Stock - B4B	50 pcs	3/20/20	3/20/20	0.00	0.00	Packaging 3 - 1 - B4B			
							Packaging 3 - 2 - B4B			

DART
AEROSPACE
Container No: S263072
Part: D2745
Job No: 207470
Serial No/Batch: S263072
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 03/12/20

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	23
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	50 pcs	3/20/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-Turn as per FOLIO FA201 FOLIO REV: AA DWG REV: B 2-DEBURR
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001
140 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	4.6000 ft (.092 ea)	100-Hardinge - 1	S243103

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R0.750	5	57	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.060inches $\pm$ 0.010	0.070 0.050	.058	caliper
2	Bushing	0.400inches $\pm$ 0.010	0.410 0.390	.403	caliper
3	Bushing	0.060inches $\pm$ 0.010	0.070 0.050	.060	caliper
4	Bushing	1.020inches $\pm$ 0.010	1.030 1.010	1.020	caliper
5	Bushing	0.030inches $\pm$ 0.010	0.040 0.020	.030	caliper
6	Bushing	20.000Degrees $\pm$ 0.000	20.000 20.000	20°	
7	Bushing	0.472inches $\pm$ 0.010	0.482 0.462	.471	Mic
8	Bushing	0.375inches + 0.006 - 0.001	0.381 0.374	.375	Mic + Pin 374
9	Bushing	0.560inches $\pm$ 0.010	0.570 0.550	.559	Mic
10	Bushing	0.750inches $\pm$ 0.010	0.760 0.740	.748	Mic

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	DEPARTMENT/PROCESS	MRB (QS1042) Disposition
Date : _____	Sequence #: _____	QTY Affected : _____	Completed By Lead hand / Supervisor QC / QA Coordinator
Description Work Order Deviation			
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____ ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			